

# Work Order ID 52817

October 15, 2009 9:20:58 AM

Page 1

Item ID: D3145-1

Revision ID: B

Item Name: Bracket

Start Date: 10/15/09 Start Qty: 1.00

Required Date: 10/19/09 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: 

QC:

Date:

Tooling:

Date:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3145

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: (2.00" x 2.00") x 4.500" (+0.030/-0.00) Long Bar

*JP 9/10/19*

1

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine per Folio FA318 and Dwg D3145-1 Deburr and Tumble

*NON DRILLED*

*SL 09/10/19*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*SL 09/10/19*

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October 15, 2009 9:20:59 AM



Page 2

Item ID: D3145-1

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Start Date: 10/15/09 Start Qty: 1.00

Required Date: 10/19/09 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*Jul 09.10.19.*

①

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

*Blk 09-10-19*

①

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

*M 11/2/14*

*Blk 09-10-19*

②

START TIME:

*3:20* FINISH TIME:

OVEN TEMPERATURE:

*9:30*

# Work Order ID 52817

October 15, 2009 9:20:59 AM

Page 3

Item ID: D3145-1

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Start Date: 10/15/09 Start Qty: 1.00

Required Date: 10/19/09 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: *W*

QC:

Date:

Tooling:

Date:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

Accept



Setup Start



Stop



Cust Item ID:

Customer:



*h 09/11/02*

*9/11/02 @ sep*

*FOR HELICORP PTY  
order # 4461*

*09/11/02*

*u 09.11.02*

# Picklist Print

October 15, 2009 9:20:58 AM

Work Order ID: 52817

Parent Item: D3145-1RevB

Parent Item Name: Bracket

Comments:



Start Date: 10/15/09

Required Date: 10/19/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.000X02.00 0		Purchased	No			100	f	13.3259	0.4035			



6061-T6 Bar 2.00 x 2.00



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	13.32586316	
110167	0.532	
13085	10.903	
17124	1.89086316	

0.4035 *ISA 09/10/09*

DART AEROSPACE LTD		Work Order: 52817
Description: Bracket		Part Number: D3145-1
Inspection Dwg: D3145	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.240	+/-0.010	<u>          </u>				
0.180	+/-0.010	<u>          </u>				
R0.250	+/-0.010	1.250	✓			
1.250	+/-0.010	<u>          </u>				
1.960	+/-0.010	1.961	✓			
Ø0.221 x 0.351	+/-0.010	<u>          </u>				
0.108	+/-0.010	.108	✓			
0.125	+/-0.010	.119	✓			
1.636	+/-0.010	1.633	✓			
R0.188	+/-0.010	1.188	✓			
0.125	+/-0.010	.118	✓			
95°	+/-0.5°	95°	✓			
R0.387	+/-0.010	1.387	✓			
0.766	+/-0.010	.766	✓			
0.250	+/-0.010	.250	✓			
1.370	+/-0.010	1.375	✓			
0.760	+/-0.010	.760	✓			
4.303	+/-0.010	4.305	✓			
0.219	+/-0.010	<u>          </u>				

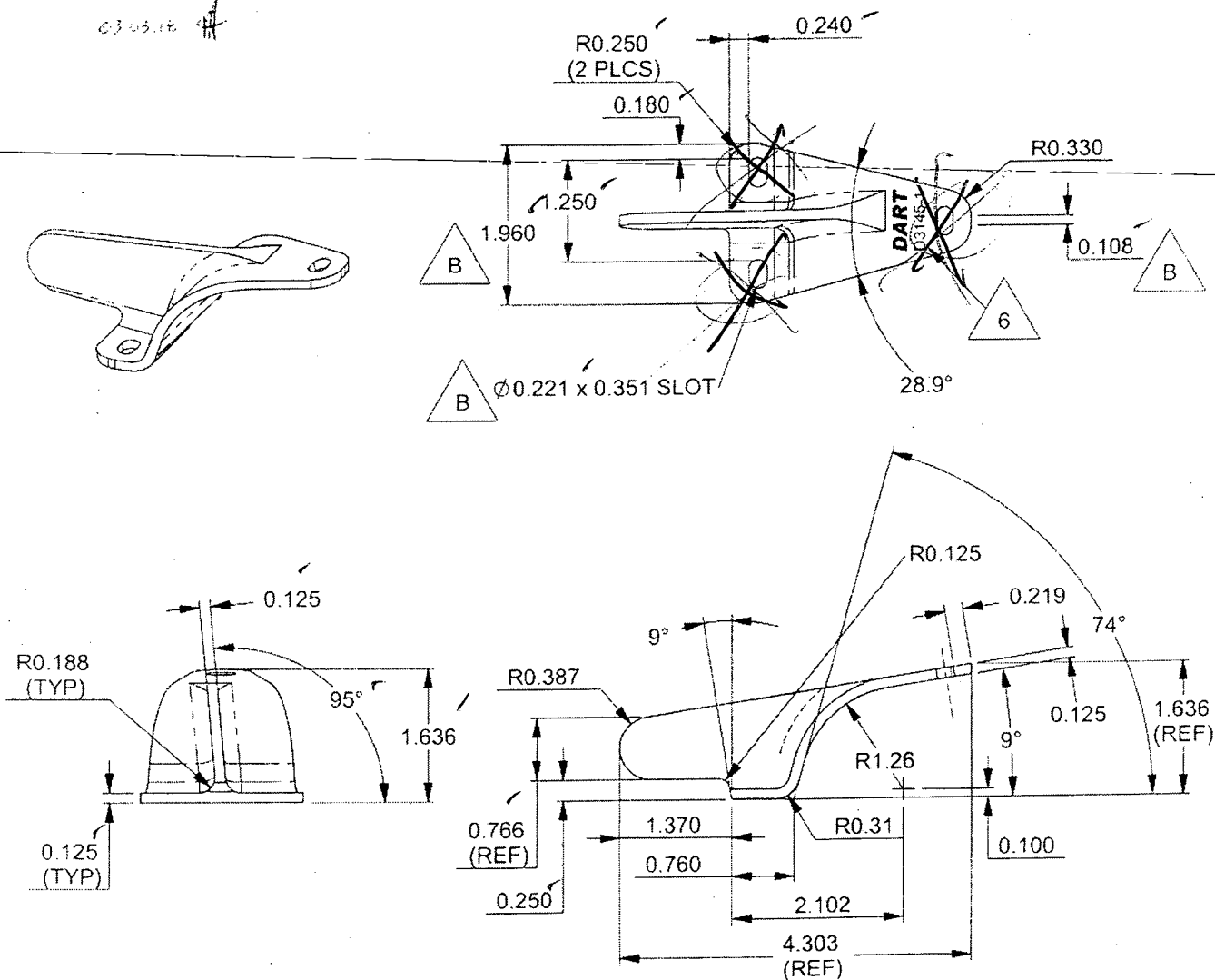
Measured by: <u>          </u>	Audited by: <u>          </u>	Prototype Approval: N/A
Date: 09/10/19	Date: 09.10.19	Date: N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	<u>          </u>



4052817

DESIGN #	DRAWN BY P	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3145	REV. B SHEET 1 OF 1
DATE 03.02.06		TITLE BRACKET	SCALE 1:2
A	02.04.24	NEW ISSUE	
B	03.02.06	ADD SLOTS; WIDEN TABS; 1.960 WAS 2.000	



D3145-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-25  
(D3145-2 BRACKET OPPOSITE. REPLACES PREMIER P/N B30-23000-26)

**NOTES:**

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

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